

Date: Monday, 26/01/2009 11:48:41 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY RH
Job Number	: 45238	Part Number	: D350636012
Estimate Number	: 10265	Drawing Number	: D2750 REV F
P.O. Number	:	Project Number	: N/A
This Issue	: 26/01/2009 S.O. No. :	Drawing Revision	: F
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SKIDTUBES	Due Date	: 02/02/2009 Qty: 1 Um: Each
Previous Run	: 44813		
Written By	:		
Checked & Approved By	: <u>Julie Dawson</u>		
Comment	Est Rev: I 02-09-25 Rearranged procedure steps KJ Est Rev: J 06-03-29 As per Rev D EC Est Rev: K 06-07-13 As per dsi9343 EC Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC Est Rev: M 08-04-22 update steps 4,13 DD verified by: EC Est Rev: N 08-09-23 rev F as per dwg DD verified by: ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	B-45063

AWM
9-1-27 (1)

3.0	D2744	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 242713 BE 9-1-27

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2- Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details). Drill using drill Jig DT8150 & DT8863.

AWM
9-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 26/01/2009 11:48:41 AM
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 45238

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6- Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7- Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8- Open up holes of Detail J to 0.297" (total of 2 holes per side)

9- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *M110295 DE 9-1-27*

10- Grind welds flush as per Dwg D2750 *AWM 9-1-27*

11- scribe batch #. *- AWM 9-1-27*

AWM 9-1-27

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5 09/01/27 (10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/01/27 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 9-1-28

(1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DD 9-1-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 45238

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D2739	350 I Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch: B-44885

AWM

9-1-28

①

10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B44796

(4R)

BE 09/02/02

11.0	D34903	Cross Bolt Spacer
------	--------	-------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B44901

(1R)

B45284

(3R)

BE 09/02/02

12.0	D2743	Crossbolt Spacer
------	-------	------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: B43110

BE 09/02/02

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side)
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

AWM 9-1-28

①

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

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Job Number: 45238

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R Sikaflex-291

batch: M109283

exp. date: 9-7-11

AN M 9-1-28

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 9)

A/R Aluminum Rod

batch: M110295

BE 09/02/02

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

PM 090203

11-Deburr holes

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/02/03

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/03

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Pressure wash as per QSI 005

ND 09-02-25 (X)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M1109996

START TIME: 9:30 AM

OVEN TEMPERATURE: 320°C

FINISH TIME: 10:00 AM

ND 09-02-25 (X)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
Inspect for foreign object per QSI 024

PR 09-02-26 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45238

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	ALS41032225	Insert
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Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: mp9817

UMP / FL

09/02/26

20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

MD / FL

09/02/26

21.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

Batch: B42778

UMP / FL

09/02/26

22.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: B44912

UMP / FL

09/02/26

23.0	D37931	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Batch: B45354

UMP / FL

09/02/26

24.0	D37933	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearshoe

Batch: B44913

UMP / FL

09/02/26

25.0	D37941	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: B44914

UMP / FL

09/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45238

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0	D37943	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gasket

Batch: B45356

UMD / FL

09/02/20

27.0	D353525	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B44905

UMD / FL

09/02/20

28.0	D353625	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B45354

UMD / FL

09/02/20

29.0	D35371	Wearpad
------	--------	---------



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

WEARPAD

Batch: B44815

UMD / FL

09/02/20

30.0	D36311	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Batch: B44670

UMD / FL

09/02/20

31.0	D3488042	Blade Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting, RH

Batch: B43122

UMD / FL

09/02/20

32.0	NAS1611010	O-RING
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

O-RING

NAS1611-010 batch: _____

(or MS28775-010) batch: _____

MD / FL

09/02/20

P40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/02/26	32.0	Replace O-ring WAS 1611-010 by O-Ring D2594-3 <u>Part#: 29908</u>	mg Fid	09/02/26			09/02/26

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 45238

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	NAS1611013	O-RING
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

O-RING

batch: *MI0513*

UMD / FL

09/02/26

34.0	D3492041	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: *B45561*

UMD / FL

09/02/26

35.0	D3492043	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: *B45339*

UMD / FL

09/02/26

36.0	AN3C5A	Bolt
------	--------	------



Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)

Bolt

Batch: *M110468 (X9)*

UMD / FL

09/02/26

M110916 (X25)

37.0	AN3C6A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: *M110372*

UMD / FL

09/02/26

38.0	AN6C44A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: *M110665*

UMD / FL

09/02/26

39.0	AN8C35A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: *M110105*

UMD / FL

09/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 45238

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN960C10L

washer



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

washer

Batch:

m110266 (X33)

UMD / F& 09/02/26

41.0

AN960C816L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WASHER

Batch:

m110139

UMD / F&

09/02/26

42.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch:

m110180

UMD / F&

09/02/26

43.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch:

m110584

UMD / F&

09/02/26

44.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch:

m110450

UMD / F&

09/02/26

45.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: m109956

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m109883

EXP DATE: 09/11

(XV)

MD / F&

09/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-assemble o'ring as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: *m10/223*

5-Coat all exposed fasteners with "LPS Procyon"
batch: *m10/251*

m10/251 09/02/26

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Serial 26 x 10

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: *1541031*

50

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: *14110139*

50

50.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: *11110584*

50
1X

51.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: *14110665*

9/2/26

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 45238

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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52.0	NAS1515H8L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108964

53.0	D34931	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B44886

54.0	D35321	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

spacer

Batch: B44904

55.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

56.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

57.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-03-03

45238

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA	DART AEROSPACE USA, INC.	
DRAWN		DRAWING NO. REV. F	
CHECKED		D2750 SHEET 1 OF 11	
MFG. APPR.		TITLE SCALE	
APPROVED		350 SKIDTUBE ASSEMBLY NTS	
DE APPR.			
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8

7

6

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4

3

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1

D

D

C

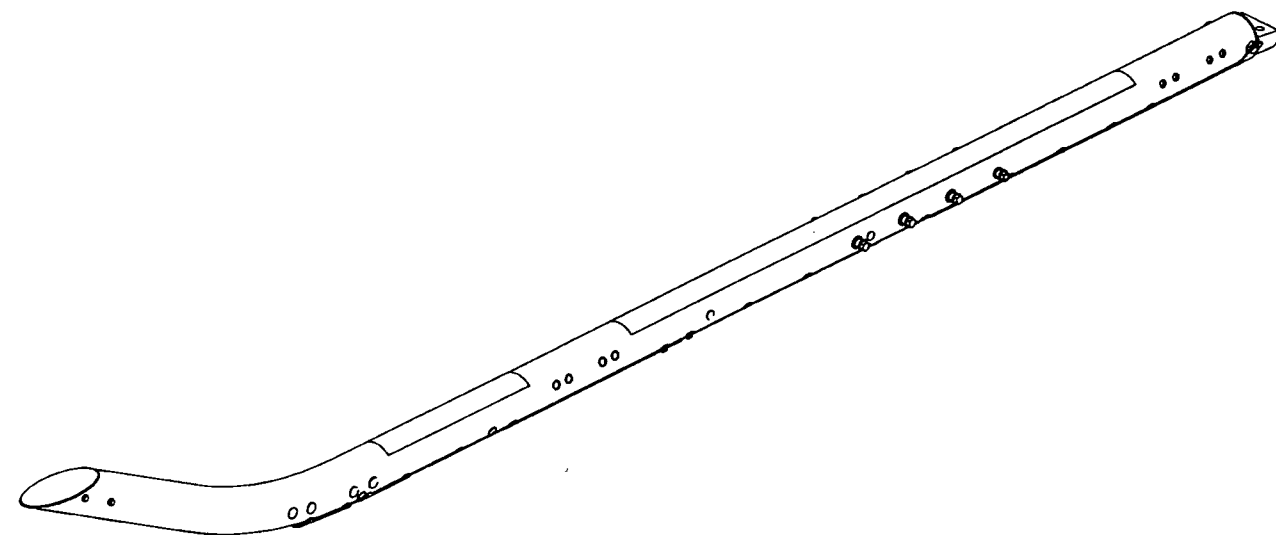
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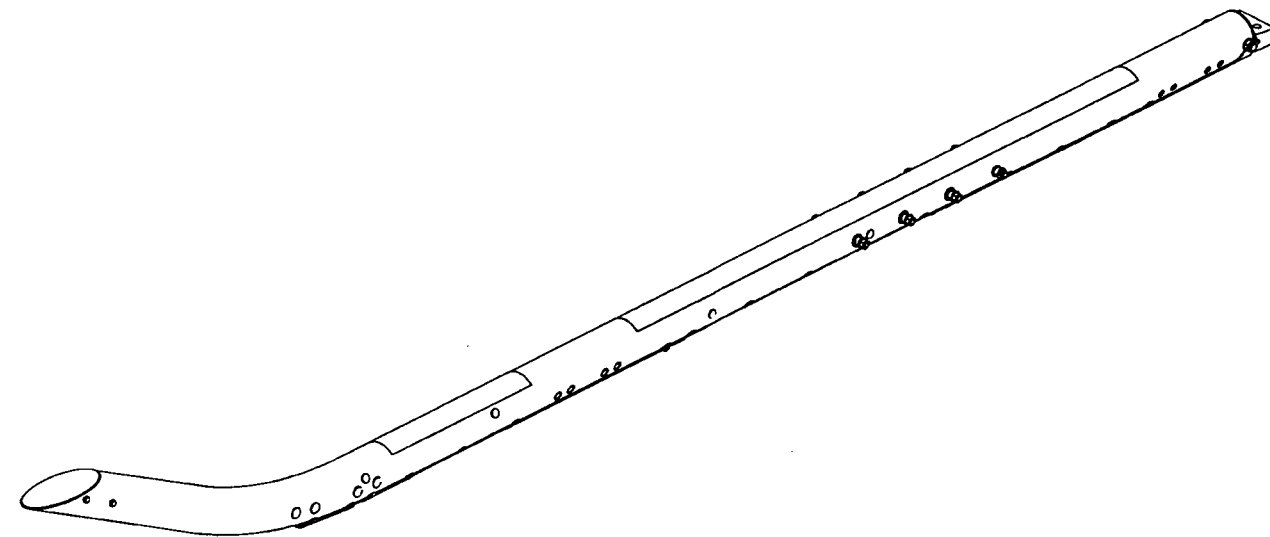
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A

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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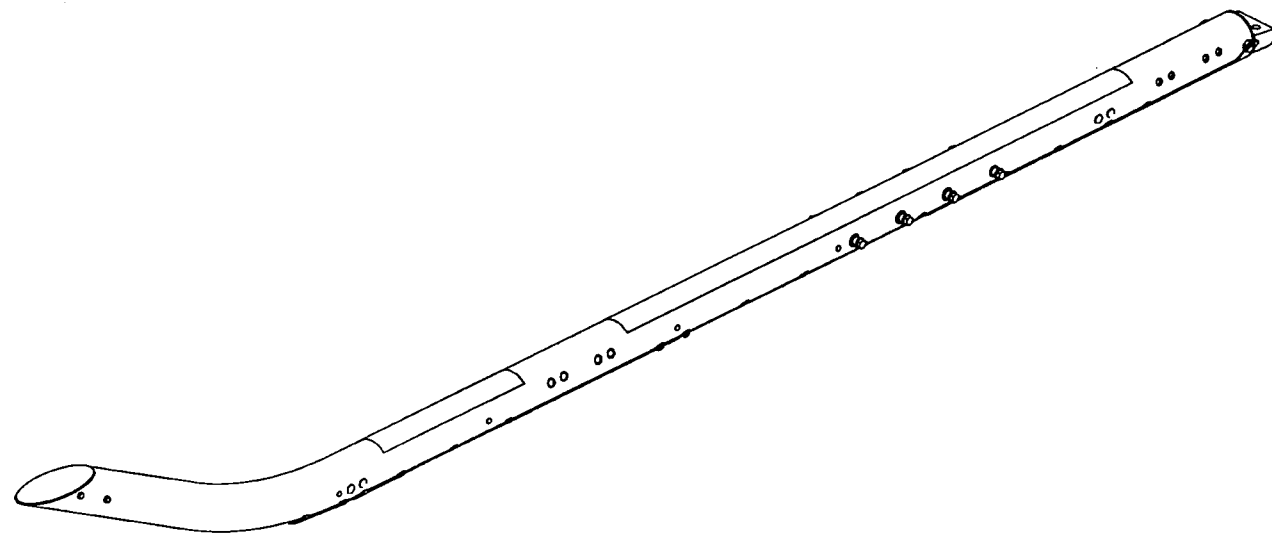
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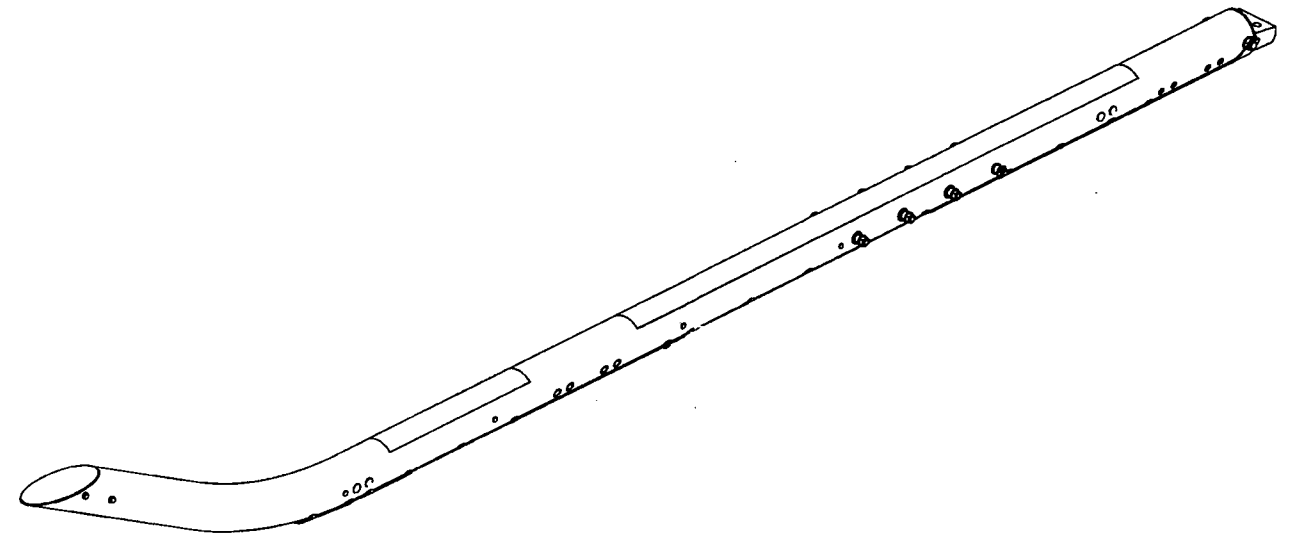
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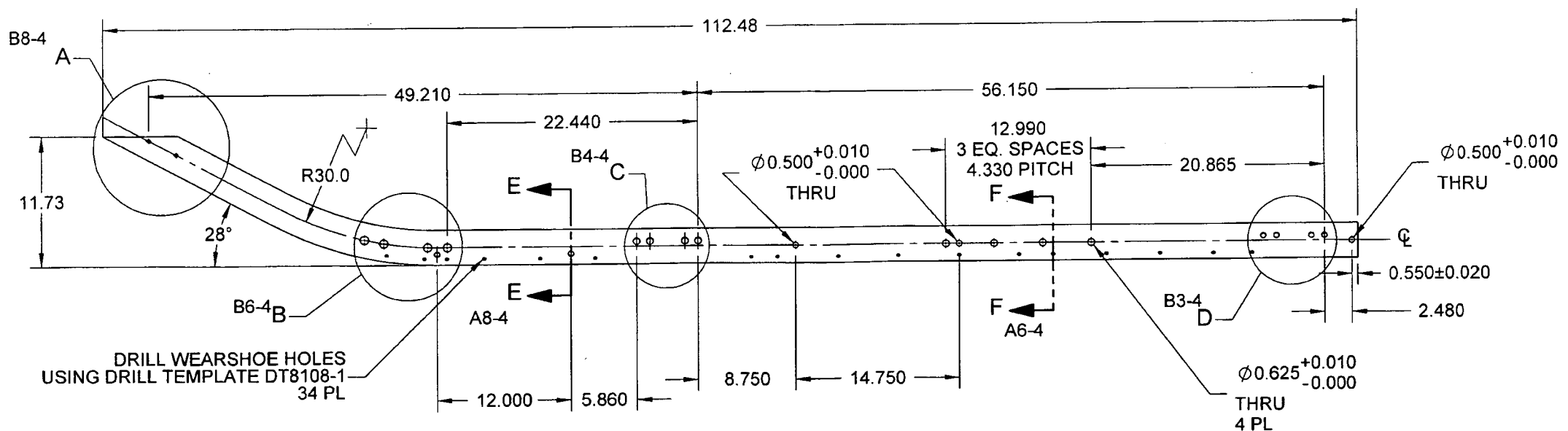


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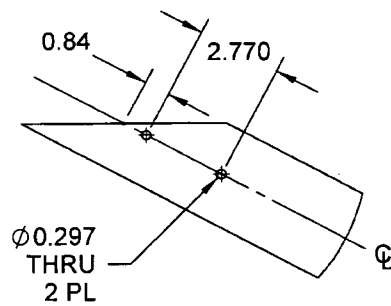
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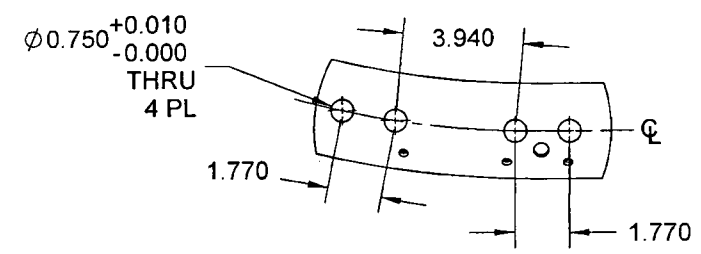
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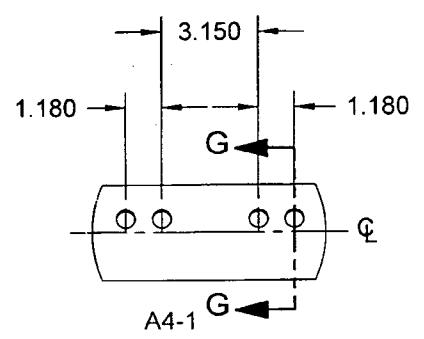
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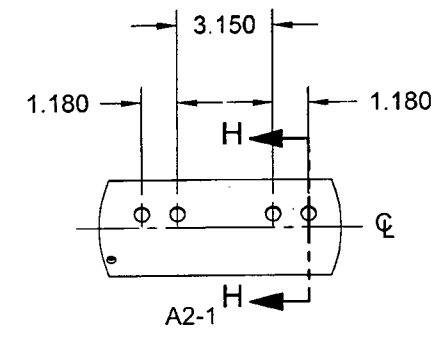
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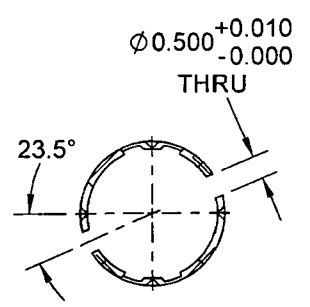
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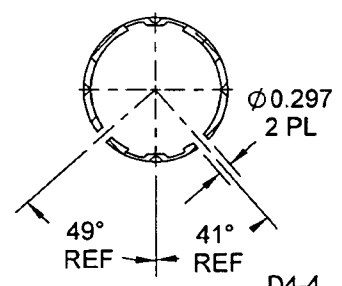
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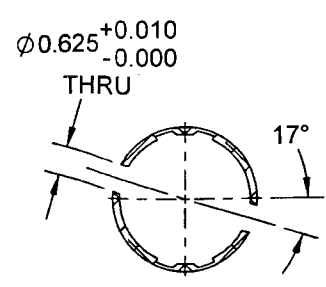
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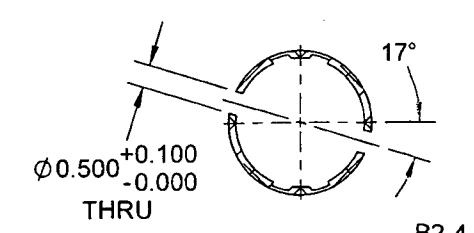
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

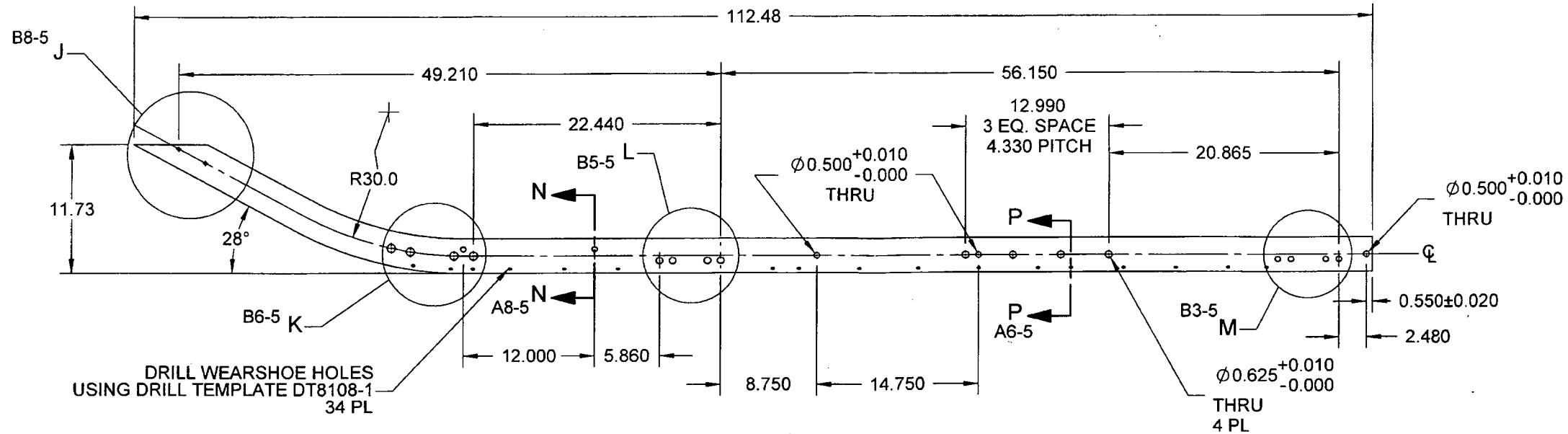


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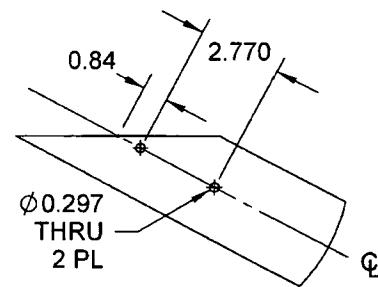
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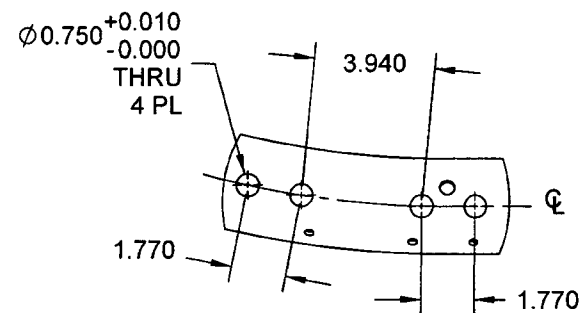
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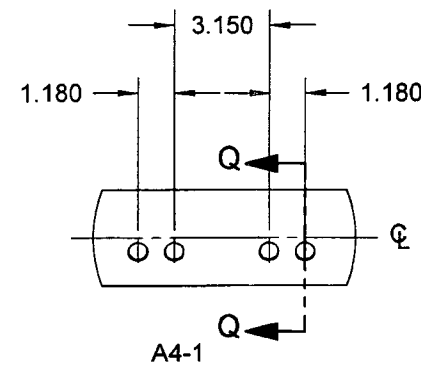
D2750-2 RH SKIDTUBE



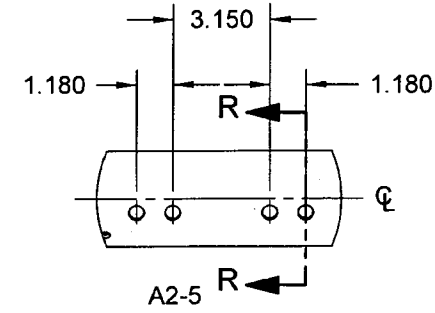
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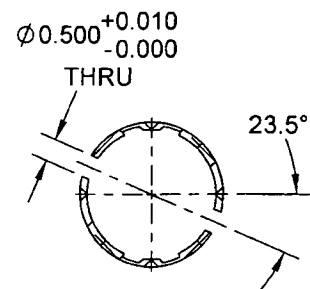
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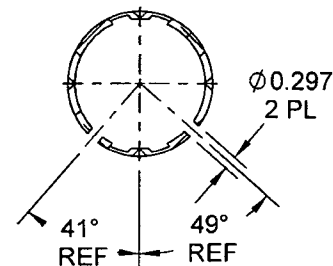
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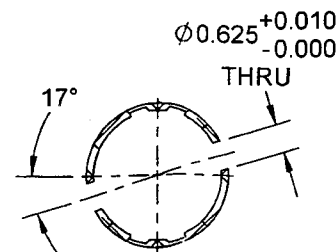
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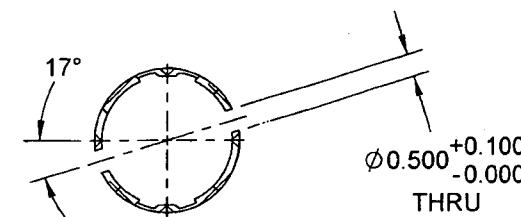
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



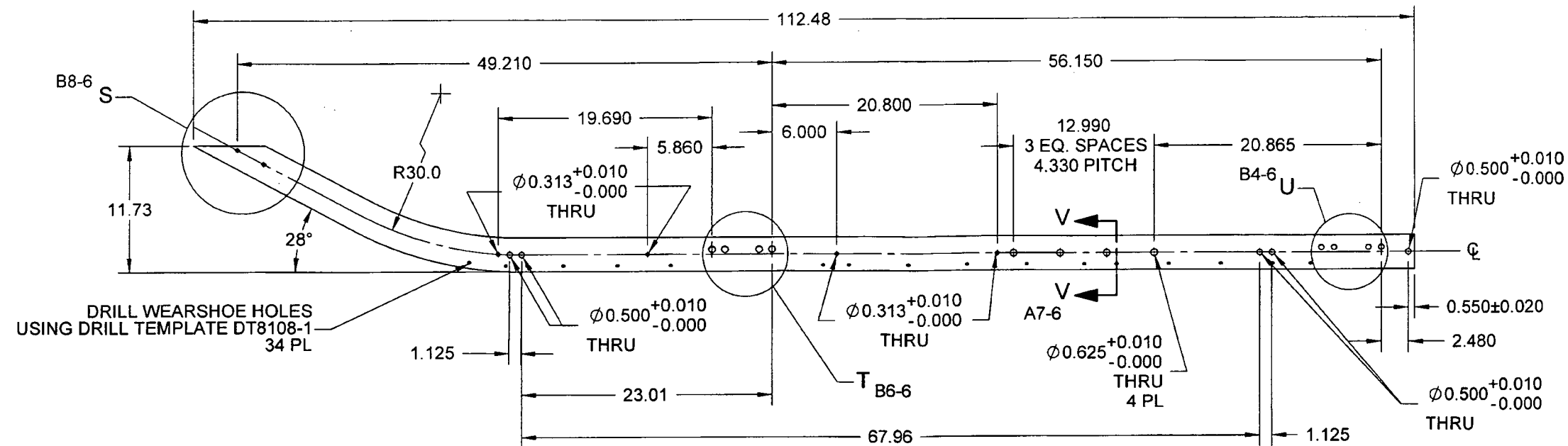
SECTION R-R
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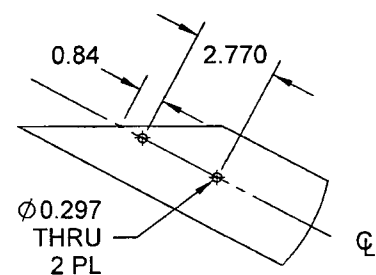
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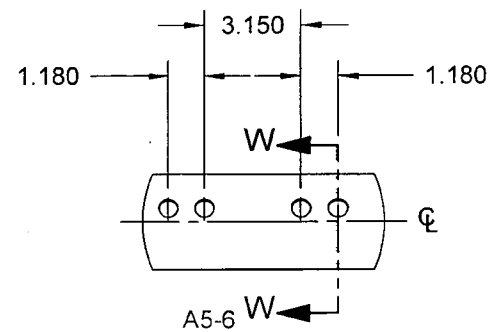
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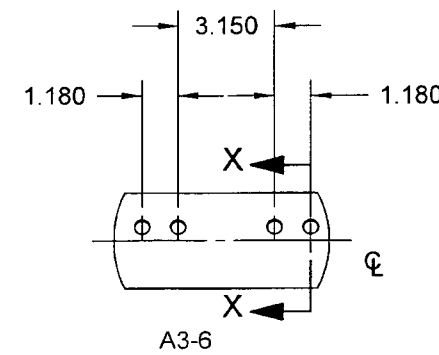
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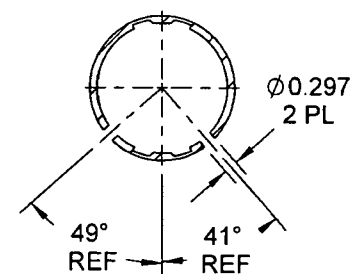
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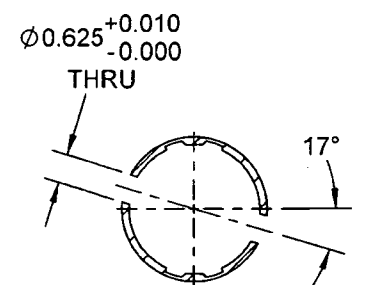
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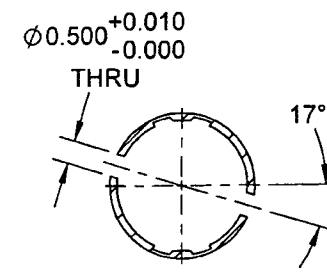
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SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



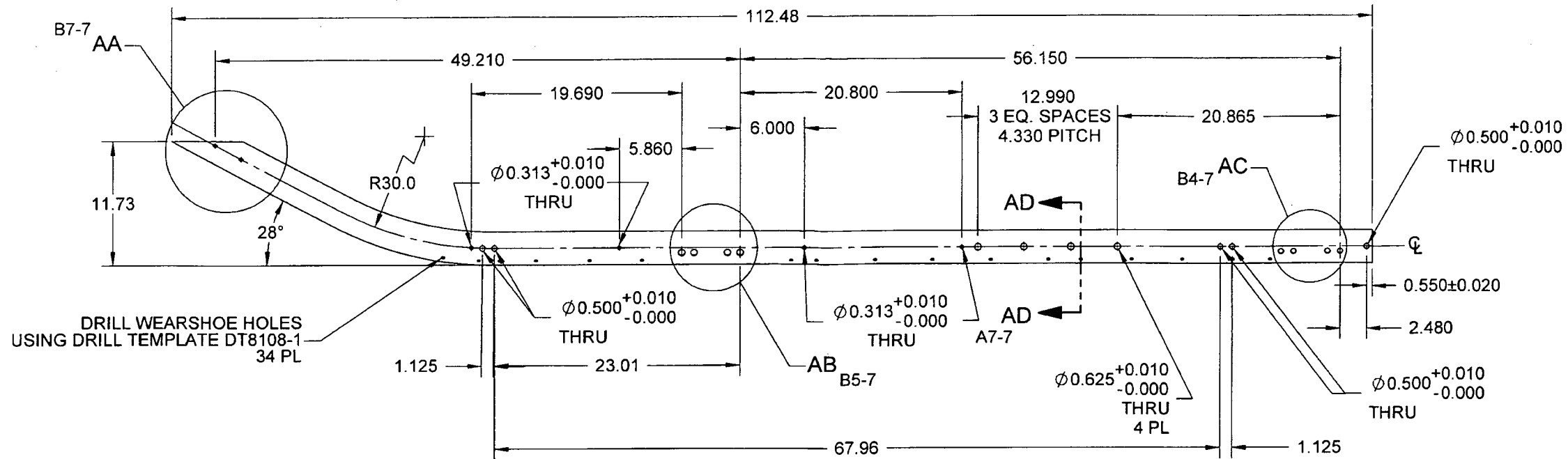
SECTION X-X
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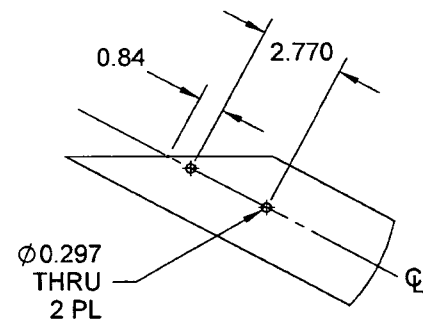
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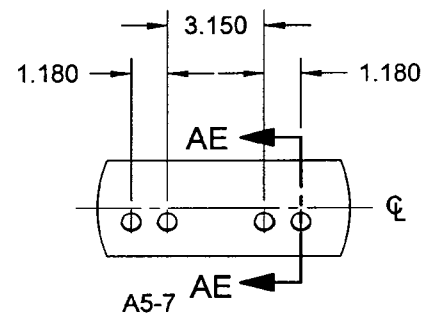
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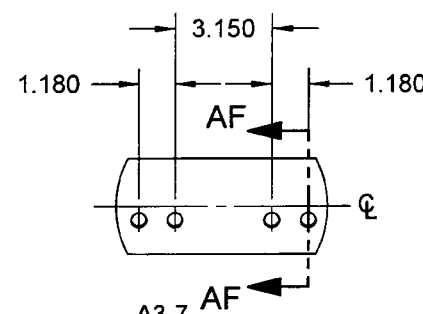
D2750-4 RH SKIDTUBE



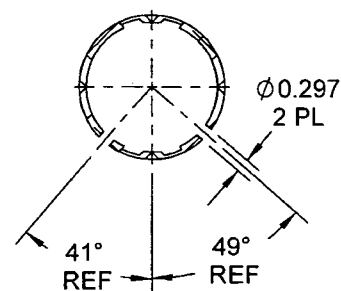
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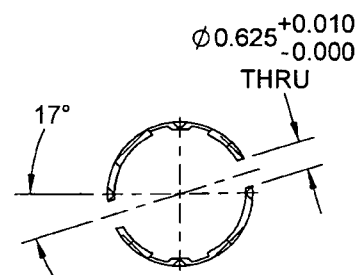
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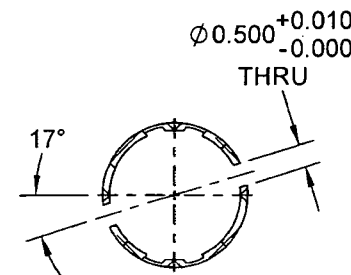
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SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

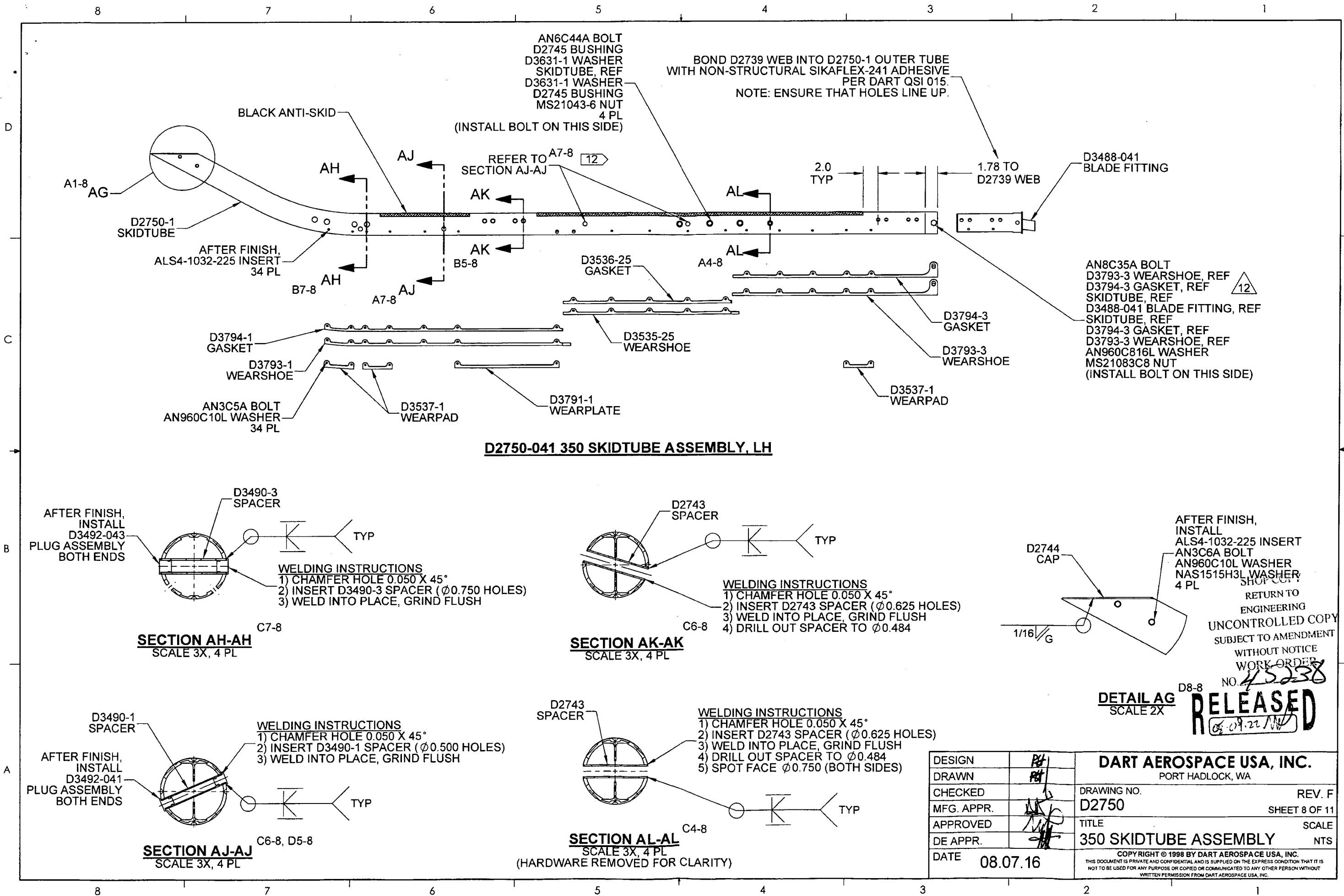


SECTION AF-AF
SCALE 3X, 4 PL

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

SECTION AH-AH
SCALE 3X, 4 PL

SECTION AK-AK
SCALE 3X, 4 PL

SECTION AJ-AJ
SCALE 3X, 4 PL

SECTION AL-AL
SCALE 3X, 4 PL
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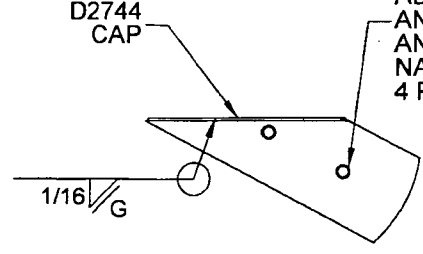
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AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL



- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 X 45°
 - 2) INSERT D2743 SPACER (Ø0.625 HOLES)
 - 3) WELD INTO PLACE, GRIND FLUSH
 - 4) DRILL OUT SPACER TO Ø0.484

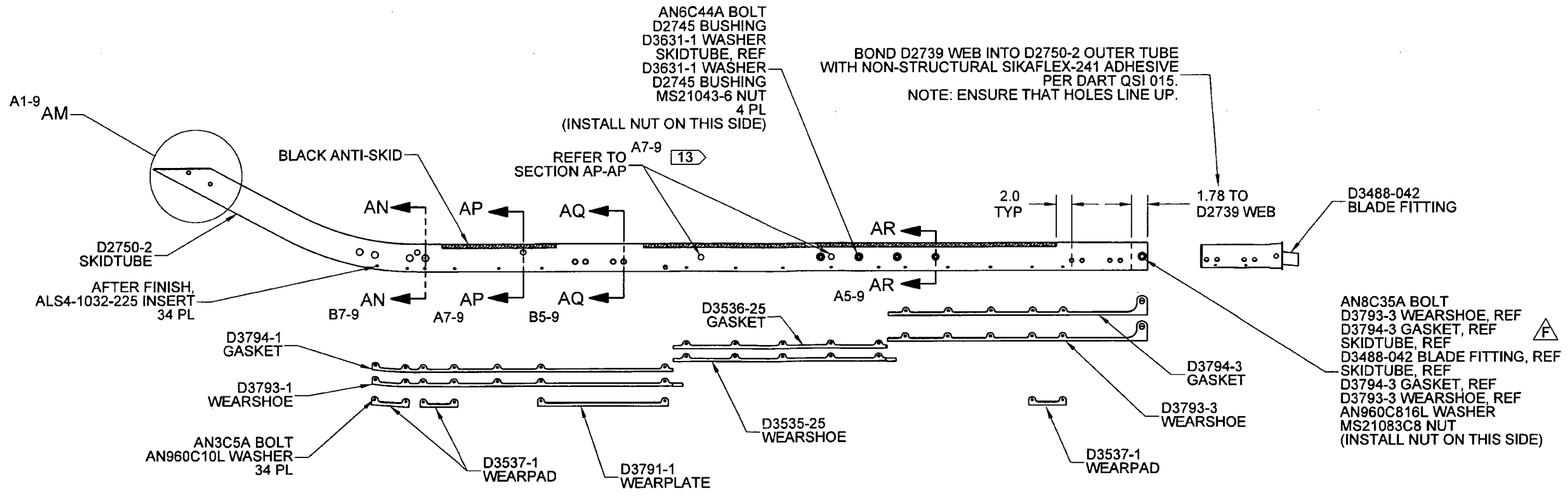
- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 X 45°
 - 2) INSERT D3490-3 SPACER (Ø0.750 HOLES)
 - 3) WELD INTO PLACE, GRIND FLUSH

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 X 45°
 - 2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
 - 3) WELD INTO PLACE, GRIND FLUSH

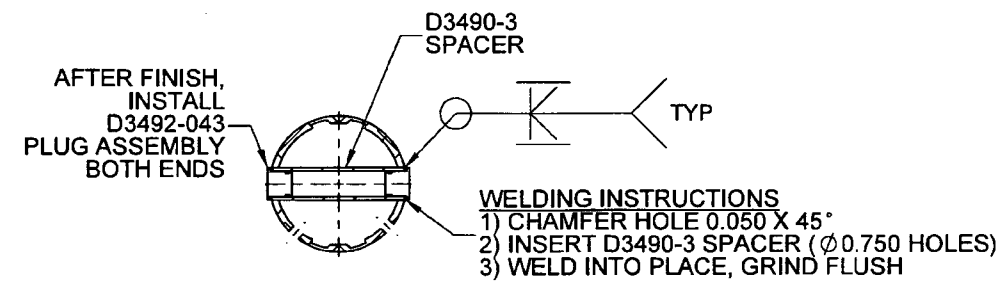
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D
C
B
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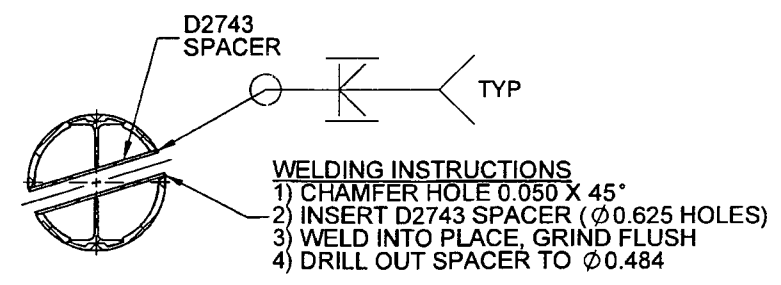
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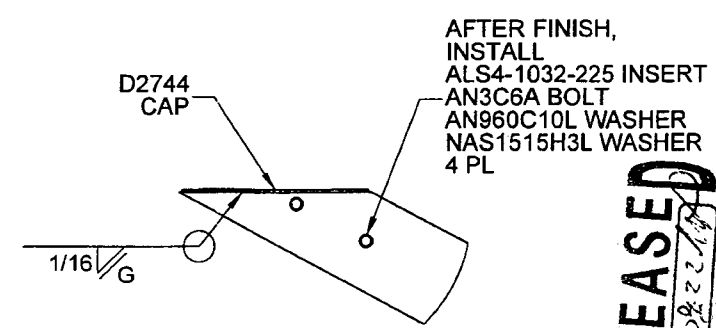
D2750-042 350 SKIDTUBE ASSEMBLY, RH



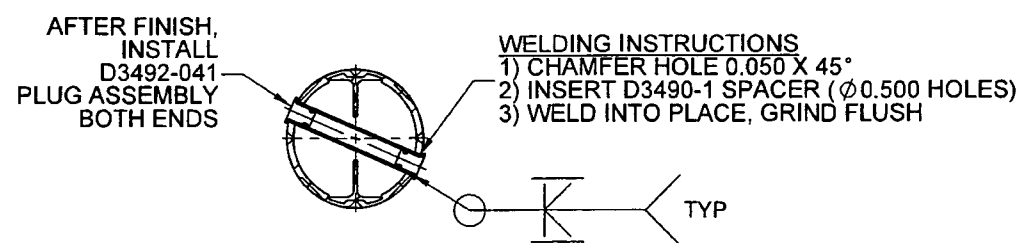
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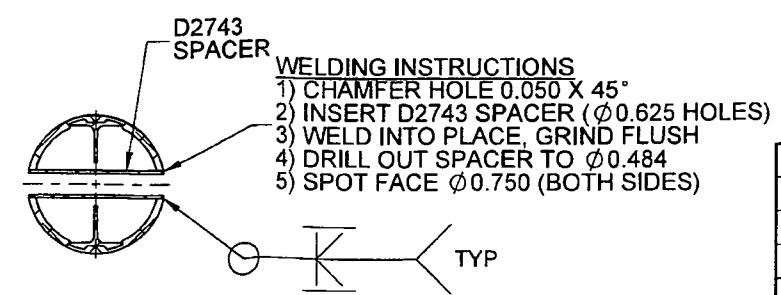
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DETAIL AM
SCALE 2X



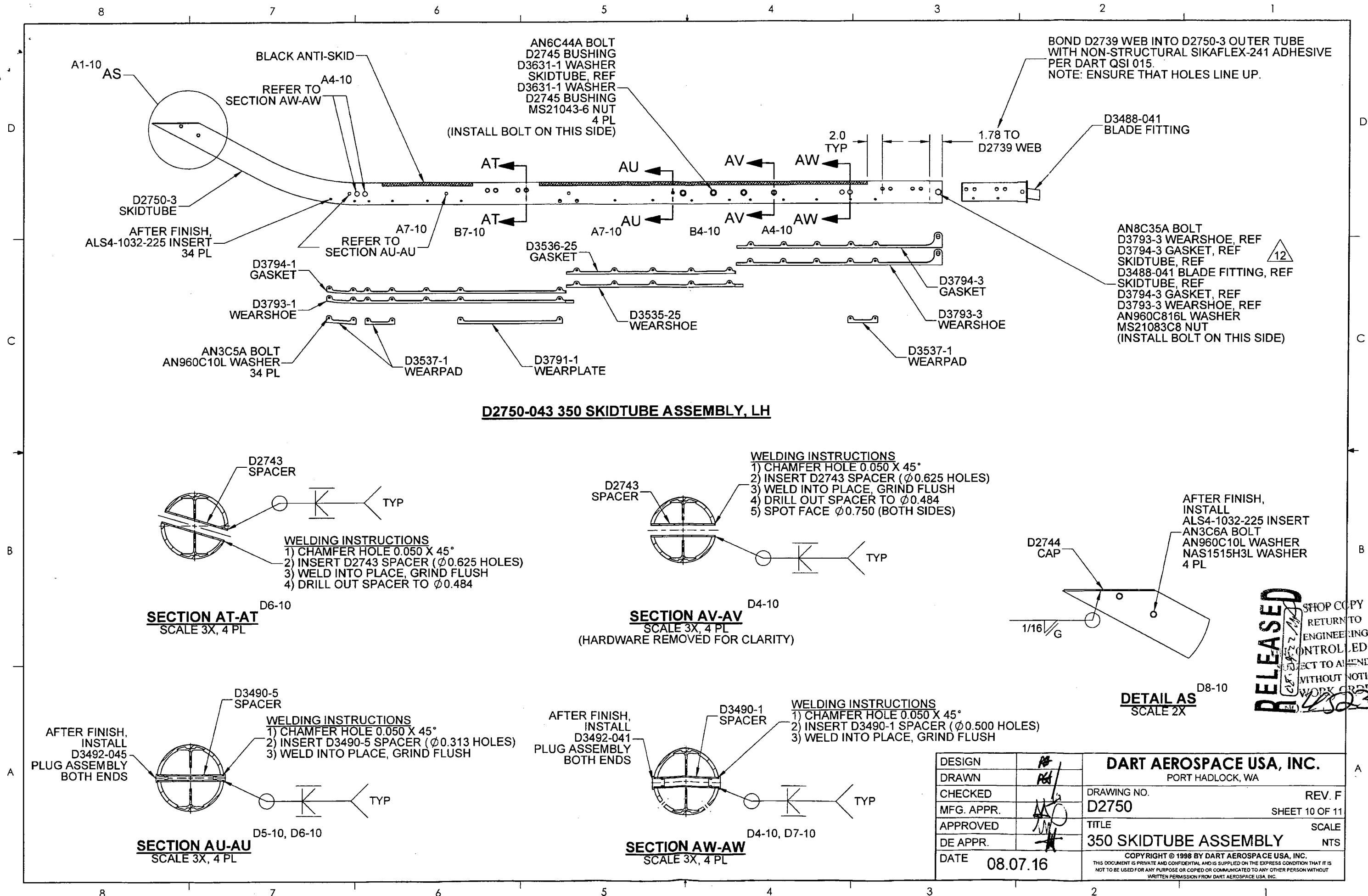
SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
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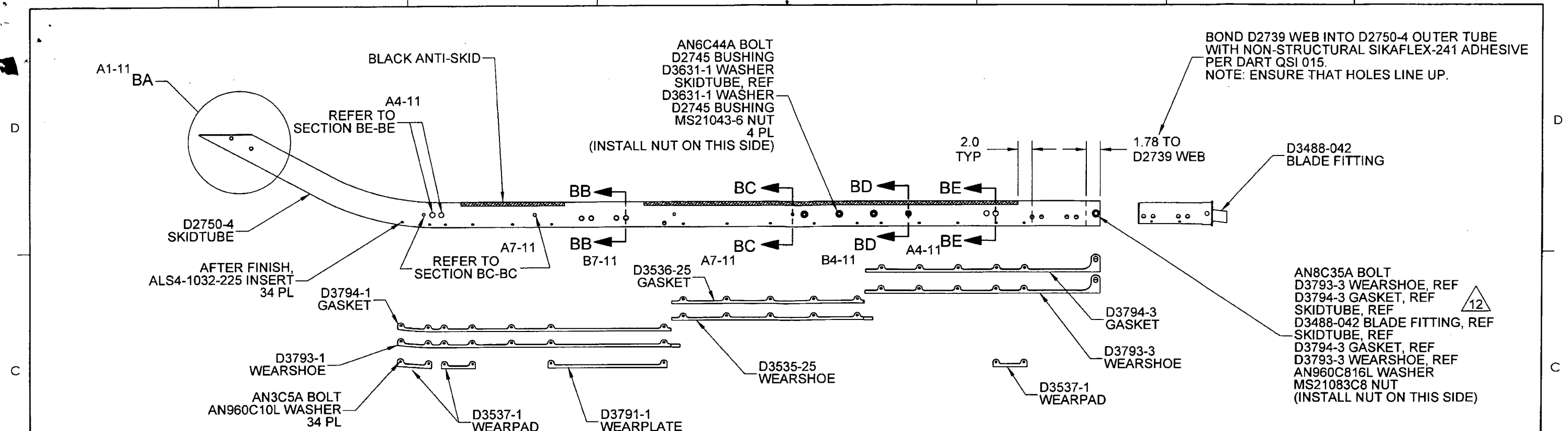
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MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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SECTION BB-BB
SCALE 3X, 4 PL

SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

SECTION BC-BC
SCALE 3X, 4 PL

SECTION BE-BE
SCALE 3X, 4 PL

DETAIL BA
SCALE 2X

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NO. 190

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bardley Elliot
Job number: 44808
Part number: D350 626 011
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pet. D. Date of Test Coupon 09-01-27
Welder Bardley Elliot Date of Test Coupon 09-01-27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld